

Date: Tuesday, 05/08/2008 10:51:11 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT BACK (AFT FACING LH/RH)	
Job Number :	40868			
Estimate Number :	13363			
P.O. Number :		Part Number :	D37743	
This Issue :	05/08/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3774 REV A B 08.08	
First Issue :	31/07/2008	Project Number :	N/A	
Previous Run :	40588	Drawing Revision :	A B	
Written By :		Material :		
Checked & Approved By :	JUD 08.08.05	Due Date :	08/08/2008	Qty: 10 Um: Each
Comment :	Est. REV:A New Issue 08.06.04 DL verified by:DD			

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3774-3

Set up clamping frame as per folio

08.08.05 DL

2.0

MLEXS125F6002904

GE PLASTICS LEXAN SHEET



Comment: Qty.: 10.6670 sf(s)/Unit Total: 106.6700 sf(s)

GE PLASTICS LEXAN SHEET

batch: M103106

08.08.05 DL

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

08.08.05 DL X10

4.0

THERMOFORMING

THERMOFORMING MACHINE



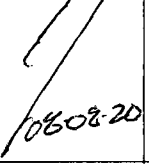
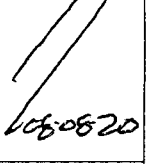
Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

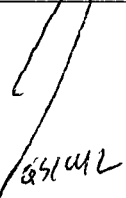
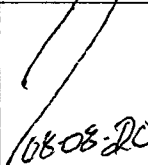

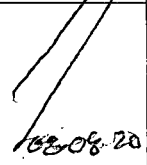
Dwg. Rev. BFolio Rev. A

08.08.06 DL X10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector
08.08.11	5	Trim as per Rev B. (drawings attached)	DL	08.08.11	all	 08.08.20	 08.08.20

Part No: D3774-3 PAR #: N/A Fault Category: Thermoforging NCR: Yes No DQA: LL Date: 08.08.12
D412 765-043/044 QA: N/C Closed: LD Date: 08/08/26

NCR: 40868		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.12	6.	DRILLED HOLE IN WRONG LOCATION.	 08/08/12	Scrap 1" part. (#2 part)	08.08.12 DL	 08.08.20	 08/08/20	 08.08.20

NOTE: Date & initial all entries

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK (AFT FACING LH/RH)

Job Number: 40868

Part Number: D37743

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

08.08.06
Sh (X10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



08.08.12.

UL (X9) RTO

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

UL 08.08.14

(X9)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1608-20 (9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PPP STORES

MF 08-08-21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21 (X)

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		WORK ORDER:	40868 #1
Description: Seat Back (Aft Facing)		Part Number:	D37743
Inspection Dwg:	D3774	Rev:	B
			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	Dh
Free of visual flaws (bumps, cracks, voids, etc.)	Dh.

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.29	✓			
1.9"	+/- 0.100"	1.925	✓			
33.9"	+/- 0.100"	33.9	✓			
0.065"	MIN	0.076	✓			
0.085"	MIN	0.096	✓			
0.100"	MIN	0.125	✓			
0.100"	MIN	0.167	✓			
0.100"	MIN	0.164	✓			
0.100"	MIN	0.164	✓			
0.100"	MIN	0.155	✓			
0.100"	MIN	0.175	✓			
0.100"	MIN	0.145	✓			

Measured by:	Dh.
Date:	08.08.11

Audited by:	BB
Date:	08/08/11

Prototype Approval:	-
Date:	

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD	WORK ORDER:	40868 #3
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable sharp definition	DL
Free of visible (etc.)	DL

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3"	✓			
1.9"	+/- 0.100"	1.9"	✓			
33.9"	+/- 0.100"	33.9"	✓			
0.065"	MIN	0.067	✓			
0.085"	MIN	0.092	✓			
0.100"	MIN	0.125	✓			
0.100"	MIN	0.133	✓			
0.100"	MIN	0.119	✓			
0.100"	MIN	0.119	✓			
0.100"	MIN	0.123	✓			
0.100"	MIN	0.131	✓			
0.100"	MIN	0.121	✓			

Measured by: DL	Audited by: BS	Prototype Approval:
Date: 08.08.14	Date: 08/08/14	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		DL

DART AEROSPACE LTD		WORK ORDER:	40868 #4
Description: Seat Back (Aft Facing)		Part Number:	D37743
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	DL
Free of visual flaws (bumps, cracks, voids, etc.)	DL

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3"	✓			
1.9"	+/- 0.100"	1.9"	✓			
33.9"	+/- 0.100"	33.9"	✓			
0.065"	MIN	0.067"	✓			
0.085"	MIN	0.105"	✓			
0.100"	MIN	0.121"	✓			
0.100"	MIN	0.149"	✓			
0.100"	MIN	0.121"	✓			
0.100"	MIN	0.122"	✓			
0.100"	MIN	0.123"	✓			
0.100"	MIN	0.136"	✓			
0.100"	MIN	0.122"	✓			

Measured by: <u>DL</u>	Audited by: <u>DL</u>	Prototype Approval:
Date: <u>08.08.14</u>	Date: <u>08.08.14</u>	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		<u>DL</u>

DART AEROSPACE LTD	WORK ORDER:	40 568 #5
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	DL
Free of visual flaws (bumps, cracks, voids, etc.)	DL

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3 "				
1.9"	+/- 0.100"	1.9 "				
33.9"	+/- 0.100"	33.9 "				
0.065"	MIN	0.076 "				
0.085"	MIN	0.091 "				
0.100"	MIN	0.144 "				
0.100"	MIN	0.162 "				
0.100"	MIN	0.147 "				
0.100"	MIN	0.149 "				
0.100"	MIN	0.139 "				
0.100"	MIN	0.152 "				
0.100"	MIN	0.132 "				

Measured by: DL	Audited by: BB	Prototype Approval:
Date: 08.08.14	Date: 08.08.14	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD	WORK ORDER:	40868 #6
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	<i>WJ</i>
Free of visual flaws (bumps, cracks, voids, etc.)	<i>WJ</i>

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3	✓			
1.9"	+/- 0.100"	1.9	✓			
33.9"	+/- 0.100"	33.9	✓			
0.065"	MIN	0.065	✓			
0.085"	MIN	0.080	✓			
0.100"	MIN	0.119	✓			
0.100"	MIN	0.134	✓			
0.100"	MIN	0.124	✓			
0.100"	MIN	0.140	✓			
0.100"	MIN	0.125	✓			
0.100"	MIN	0.137	✓			
0.100"	MIN	0.125	✓			

Measured by: <i>WJ</i>	Audited by: <i>BB</i>	Prototype Approval:
Date: <i>08.08.14</i>	Date: <i>08/08/14</i>	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		<i>[Signature]</i>

DART AEROSPACE LTD	WORK ORDER: 40868 #7
Description: Seat Back (Aft Facing)	Part Number: D3774
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	Oh
Free of visual flaws (bumps, cracks, voids, etc.)	Oh

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3"	✓			
1.9"	+/- 0.100"	1.9"	✓			
33.9"	+/- 0.100"	33.9"	✓			
0.065"	MIN	0.071"	✓			
0.085"	MIN	0.096"	✓			
0.100"	MIN	0.135"	✓			
0.100"	MIN	0.172"	✓			
0.100"	MIN	0.145"	✓			
0.100"	MIN	0.154"	✓			
0.100"	MIN	0.118"	✓			
0.100"	MIN	0.150"	✓			
0.100"	MIN	0.128"	✓			

Measured by: Oh	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 08.02.14	Date: 08.08.14	Date: [Blank]

Rev	Date	Change	Revised by	Approved
		New Issue		[Signature]

DART AEROSPACE LTD	WORK ORDER: 40868 #8
Description: Seat Back (Aft Facing)	Part Number: D37743
Inspection Dwg: D3774 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	OK
Free of visual flaws (bumps, cracks, voids, etc.)	OK

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3	✓			
1.9"	+/- 0.100"	1.9	✓			
33.9"	+/- 0.100"	33.9	✓			
0.065"	MIN	0.075"	✓			
0.085"	MIN	0.095"	✓			
0.100"	MIN	0.135	✓			
0.100"	MIN	0.147	✓			
0.100"	MIN	0.165	✓			
0.100"	MIN	0.172	✓			
0.100"	MIN	0.172	✓			
0.100"	MIN	0.173	✓			
0.100"	MIN	0.146	✓			

Measured by: <u>wh.</u>	Audited by: <u>BP</u>	Prototype Approval:
Date: <u>08.03.14</u>	Date: <u>08/05/14</u>	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD		WORK ORDER: 40868	49
Description: Seat Back (Aft Facing)		Part Number: D3774	
Inspection Dwg: D3774 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	19/11
Free of visual flaws (bumps, cracks, voids, etc.)	19/11

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3"	✓			
1.9"	+/- 0.100"	1.9"	✓			
33.9"	+/- 0.100"	33.9"	✓			
0.065"	MIN	0.066"	✓			
0.085"	MIN	0.086"	✓			
0.100"	MIN	0.124"	✓			
0.100"	MIN	0.150"	✓			
0.100"	MIN	0.124"	✓			
0.100"	MIN	0.126"	✓			
0.100"	MIN	0.147"	✓			
0.100"	MIN	0.155"	✓			
0.100"	MIN	0.126"	✓			

Measured by: <u>Sh.</u>	Audited by: <u>DS</u>	Prototype Approval: <u> </u>
Date: <u>09.08.14</u>	Date: <u>09/08/14</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD		WORK ORDER: 40868 #10
Description: Seat Back (Aft Facing)		Part Number: D3774
Inspection Dwg: D3774	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	OK
Free of visual flaws (bumps, cracks, voids, etc.)	OK

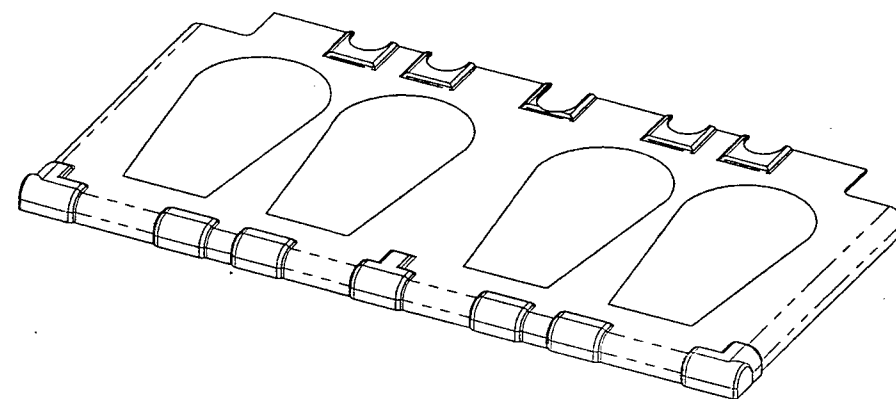
(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3774 Rev. B and record below

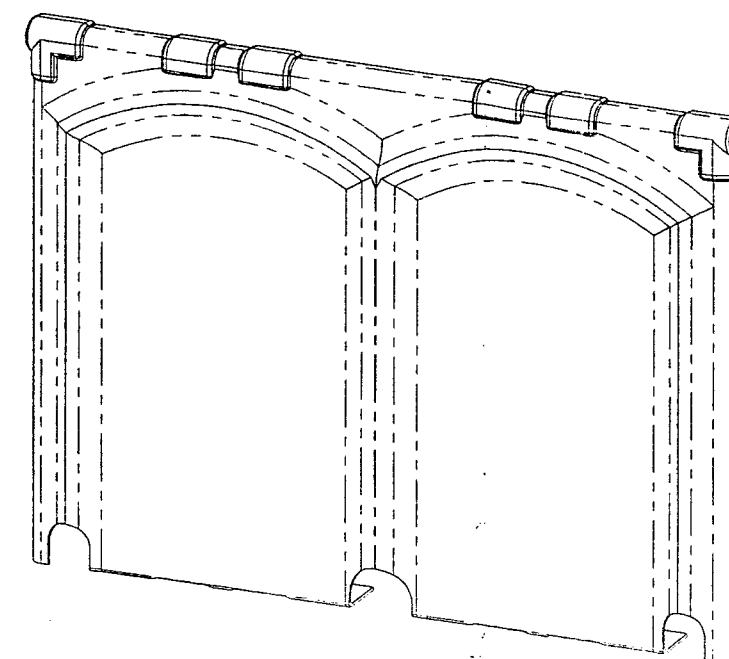
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.3	✓			
1.9"	+/- 0.100"	1.9	✓			
33.9"	+/- 0.100"	33.9	✓			
0.065"	MIN	0.075"	✓			
0.085"	MIN	0.091"	✓			
0.100"	MIN	0.140"	✓			
0.100"	MIN	0.168"	✓			
0.100"	MIN	0.145"	✓			
0.100"	MIN	0.145"	✓			
0.100"	MIN	0.143"	✓			
0.100"	MIN	0.148"	✓			
0.100"	MIN	0.135"	✓			

Measured by: <u>OK</u>	Audited by: <u>TS</u>	Prototype Approval: <u> </u>
Date: <u>02.08.14</u>	Date: <u>08/08/14</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
		New Issue		



D3774-1 SEAT BOTTOM

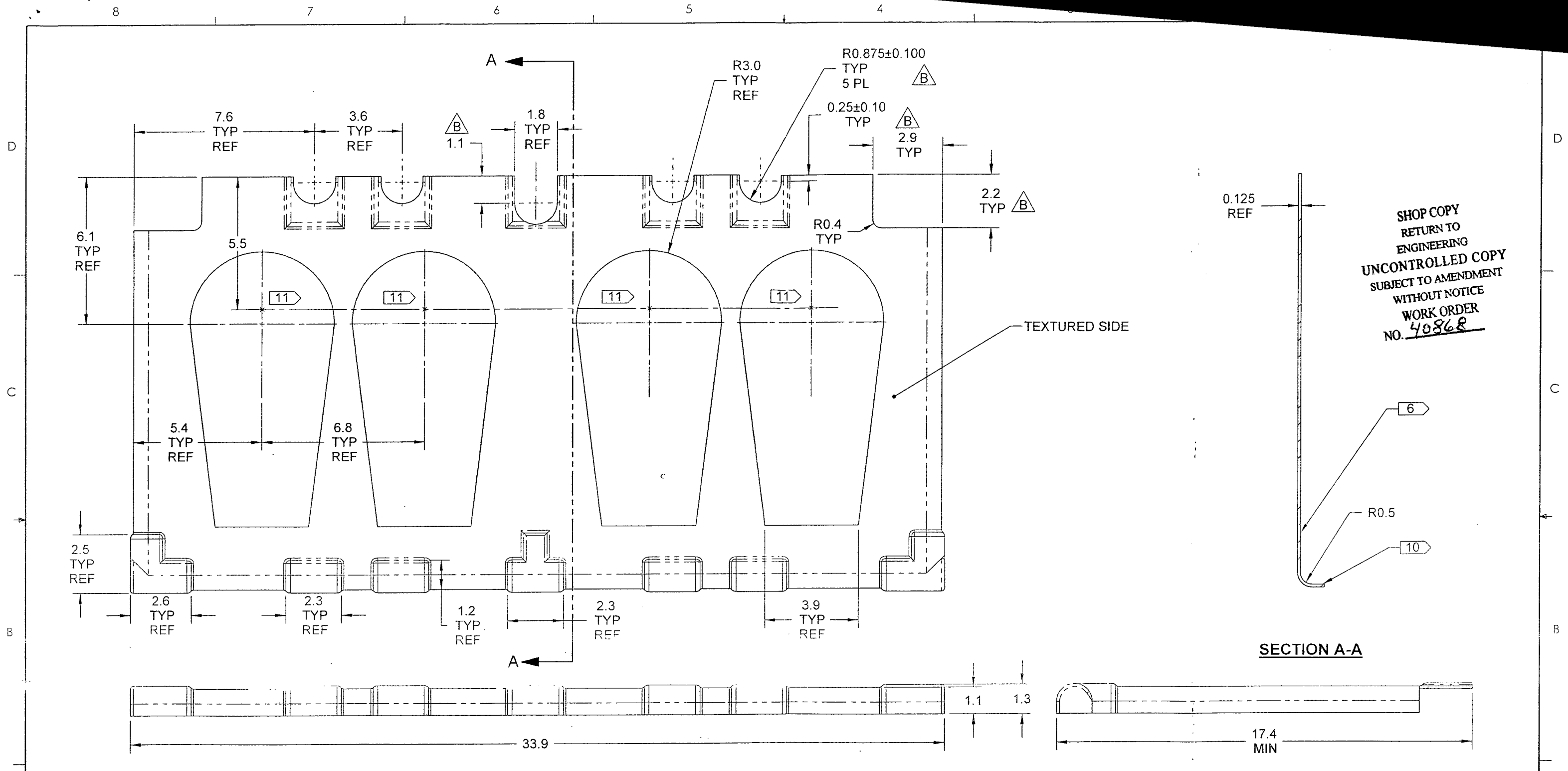


D3774-3 SEAT BACK

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WITHOUT NOTICE
WORK ORDER
NO. 40868

RELEASED
08-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3774	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	








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WITHOUT NOTICE
WORK ORDER
NO. 40868

SECTION A-A

D3774-1 SEAT BOTTOM

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 2.93 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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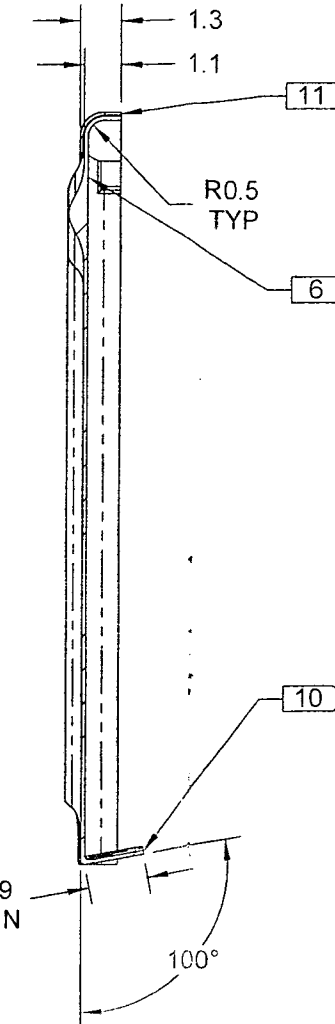
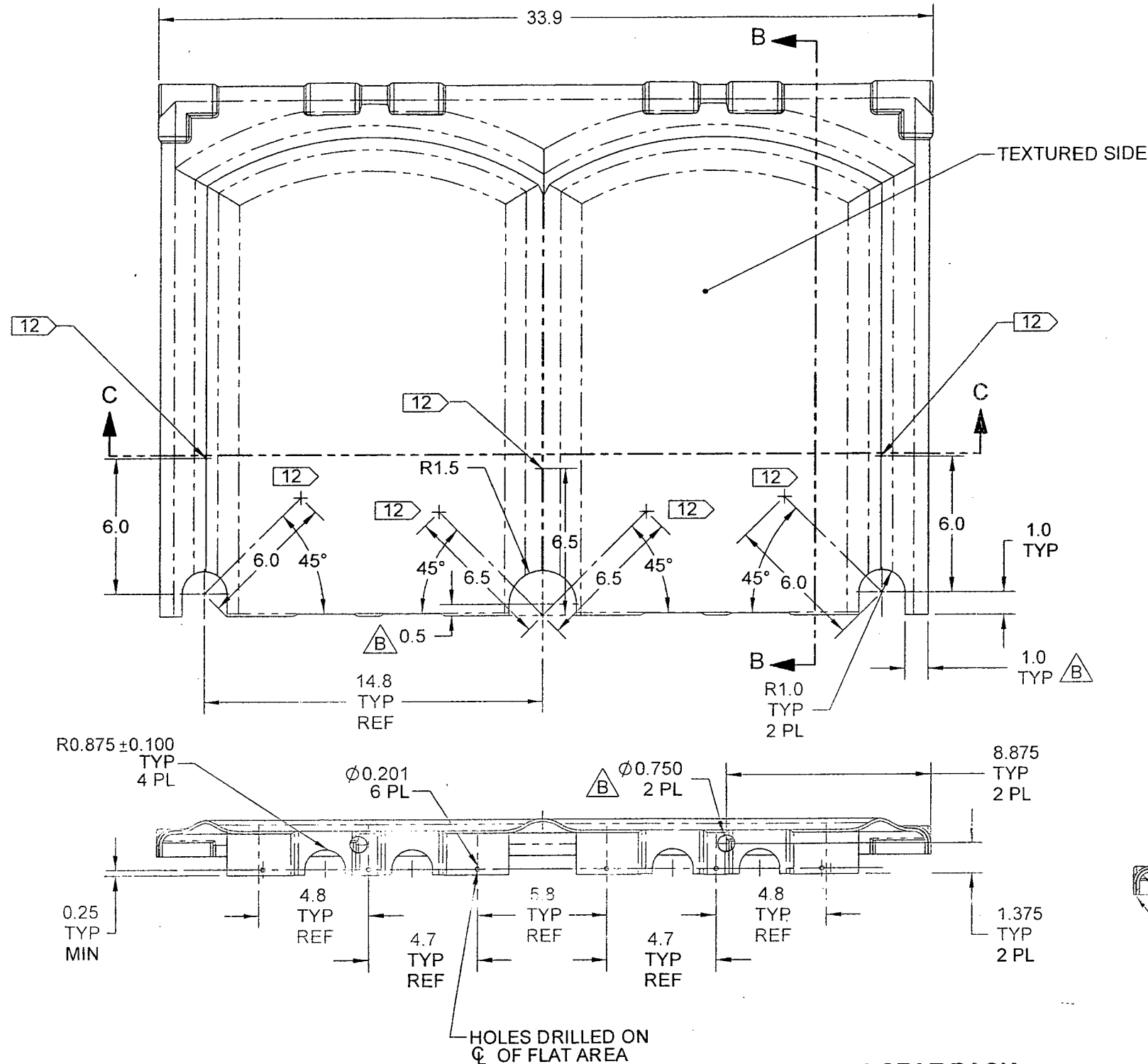
8

7

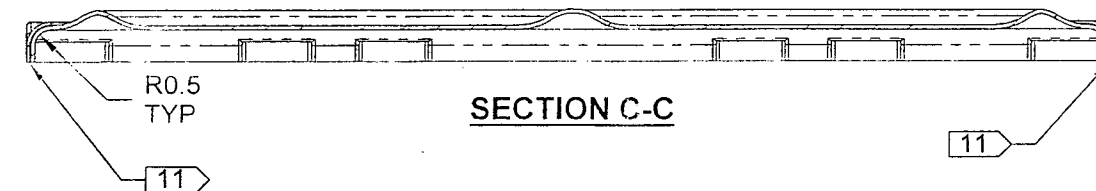
6

5

4



SECTION B-B



SECTION C-C

SHOP COPY
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ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40868

D3774-3 SEAT BACK

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: 4.82 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	RS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WJ	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3774	SHEET 3 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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